

Ship 28-31/08

# Work Order ID 51681

August 27, 2009 9:21:29 AM



Item ID: D3880-3  
Revision ID: A  
Item Name: Floor Doubler

Accept



Setup Start



Stop



Start Date: 8/27/09 Start Qty: 8.00  
Required Date: 8/28/09 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3880

Dwg Rev: A

Prog Rev: A

6061 .020

2- Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

AB 9-8-28

(10)

AB 9-8-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Customer:

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QC:

Date:  
Date:

Tooling:  
SPC (Y/N):

Date:  
Date:

Run Start  
Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 502/08/28

100

✓

130

0.00



Small Fab

Memo

0.00

Small Fab

1- C'sink holes as per dwg  
2- Break edge per dwg  
3- deburr

> m-h 09/08/31

10X

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 502/08/31

100

✓

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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August 27, 2009 9:21:29 AM

**Accept**

**Start Date:** 8/27/09      **Start Qty:** 8.00  
**Required Date:** 8/28/09      **Req'd Qty:** 8.00

**Cust Item ID:**  
**Customer:**

**Reference:**

<b>Approvals:</b>	<b>Process Plan:</b>	<b>Date:</b>	<b>Tooling:</b>	<b>Date:</b>
	<b>QC:</b>	<b>Date:</b>	<b>SPC (Y/N):</b>	<b>Date:</b>

Run	Start
	Stop

**Sequence ID/  
Work Center ID**

### Operation Description

## Set Up/ Run Hours

**Draw  
Number**

**Draw  
Rev.**

**Plan  
Code**

**Accept Qty**

Reject  
Qty**Reject  
Number**

**Insp.  
Stamp**

150

Chemical Conversion Coat per QSI005 4.1

0.00

BK 09-08-31

10

HandFinish

## Memo

0.00

## Hand Finishing

160

QC3- Inspect Part Finish

0.00

09-08-31 10

QC

## Memo

0.00

## Quality Control

170

Identify as per dwg & Stock Location: B7

0.00

19/8/37 (10)

### Packaging

## Memo

0.00

## Packaging

10/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: Date:  
QC: Date:

Tooling: Date:  
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

180



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

09/08/31

MF 09-08-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

August 27, 2009 9:21:28 AM

Page 1

Work Order ID: 51681

Parent Item: D3880-3RevA

Parent Item Name: Floor Doubler

Comments:

Start Date: 8/27/09

Required Date: 8/28/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	270.4990	0.5002			



6061-T6 .080 Sheet



VB 9-8-08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

270.499

107904

0.02

110254

2.5

110630

42.9353

112040

0.0437

112141

33

112512

192

110630

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

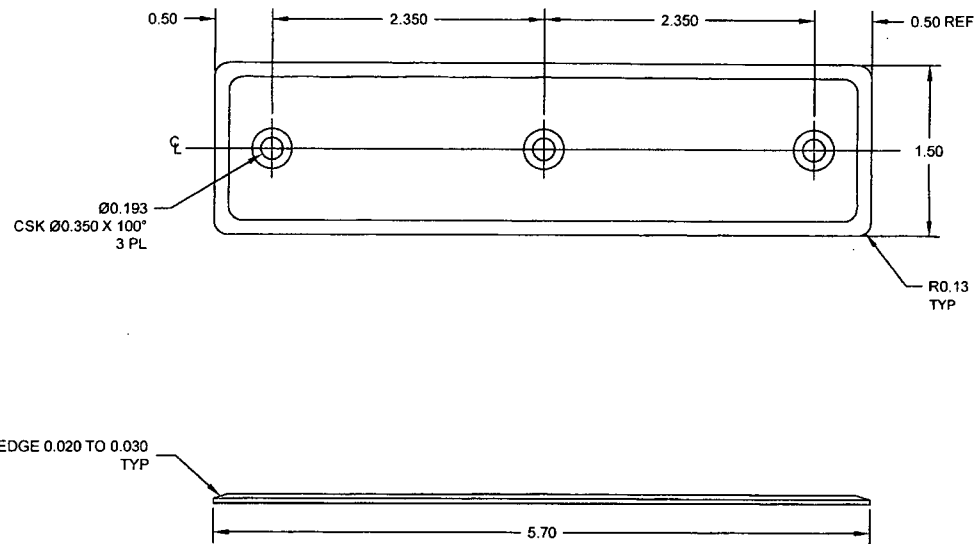
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



W/051681



**D3880-3 FLOOR DOUBLER**

**RELEASED**  
9/25/05 NTP

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/11 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK UNMARKED SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3880-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.1 LBS

DESIGN	KB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KB		
CHECKED	<del>KB</del>	DRAWING NO.	REV. A
MFG. APPR.	DD	D3880	SHEET 3 OF 3
APPROVED	<del>KB</del>	TITLE	SCALE
DE APPR.	<del>KB</del>	TAS TRAY MOUNT	NTS
DATE	09.01.22	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	